

Date: Wednesday, 22/10/2008 8:26:56 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 HIGH AFT X-TUBE ASSEMBLY
 Job Number : 41043
 Estimate Number : 10528
 P.O. Number :
 This Issue : 22/10/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : CROSSTUBES
 Previous Run : 41042
 Part Number : D407667205
 Drawing Number : D407-667-245
 Project Number : N/A
 Drawing Revision : *F 08.11.17*
 Material :
 Due Date : 07/11/2008 Qty: 1 Um: Each

Written By :
 Checked & Approved By : *JLD 08.10.22*

Comment : Est Rev:C 05.09.02 Add holes for compatibility with Bell Skidtubes KJ/JLM
 Est Rev:D Added Magnobond,Rubber Cushion & Clamps 07-02-19 JLM
 ****CHANGE TO CHG 005 - IF USING D2894-1 B35578 OR GREATER****
 Est Rev:E 08-05-22 add comment in seq. 6 and QC15 and QC5 DD verified by:EC
 Est Rev:F 08-06-12 add comment in seq. 24 DD verified by:EC
 Est Rev:G 08-08-19 revE as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



for JLD 08.8.26



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-205 CHG006

5 08/12/03

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D407667205TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 CROSSTUBE TURNING DETAIL
 batch *B343207*

DP 8-11-6

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: LANDING GEAR RESOURCE 1

1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio FT

DP 8-11-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41043

Part Number: D407667205

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

08-11-07

①

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245

6-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Note: Aft side has 3x top holes.

7-Drill Fwd rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Drill only the top (3) holes.

8-C/sink holes as per Dwg D407-667-245. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

10- Scribe tube to identify on the inner chamfer in the cuff D# and B#

MB

08-11-10

MB 08-11-10

MB 08-11-10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MB 08-11-11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-11

①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-11

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 41043

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES
Liquid Penetrant Inspection as per QSI 0380r
Issue P/O: 7627 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

08/11/19 (1)

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.

08/11/19 (1)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/11/21 (1)

13.0	SPRAY PAINTING	SPRAY PAINTING
------	----------------	----------------



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 11 26 (1)

14.0	QC14	INSPECT SPRAY PAINT
------	------	---------------------



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

08/12/01 (1)

15.0	D2856400	Abrasion Strip
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Comment: Qty.: 1.3524 f(s)/Unit Total : 1.3524 f(s)
Pick:

Qty	Part number	Description	Batch
2	D2856-400	(Cut to 7.73") Abrasion Strip	<u>37667</u>

ml 08 12 01

16.0	D2873043	Nut Plate Assembly
------	----------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part number	Description	Batch
2	D2873-043	Nut Plate	<u>41988</u>

08-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 41043

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045 Nut Plate 41987

RT 08-11-19

18.0

D28941

2.750 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2894-1 Support 43713

ml 08 12 01

19.0

D31901

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3190-1 Chafing Shield 37969

ml 08 12 01

20.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0246 sf(s)/Unit Total: 0.0246 sf(s)

Rubber Cushion

2X .750" X 4.30"

Batch: 41108

ml 08 12 01

21.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet 109297

RT 08-11-19

22.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22 Clamp 108187

ml 08 12 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 41043

Part Number: D407667205

Job Number:



Seq. #: Machine Or Operation: Description :

23.0 MS2192025 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 109644

ml 08 12 01

24.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8674. Install chafing shield as per Dwg D407-667-245.Note:
(3) top holes should be facing up.

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Install support with magnobond and install clamps as per Dwg D407-667-245 using installaiton jig DT9025.

Torque clamps to 80-100 in lb

A/R Magnobond Batch: 109900

EXP: 02/2010

4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

RT 08-11-19

25.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/02 (X1)

26.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0 AN534A Bolt



(12)

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109061

8/12/3

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41043

Part Number: D407667205

Job Number:



Seq. #: Machine Or Operation: Description :

28.0 MS21042L5 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch: M109297

sq

29.0 AN510A Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M109287

sq

30.0 AN532A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M109282

sq

31.0 AN960JD516 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M109282

8/12/3

(K)

sq

32.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/12/03 (K)

33.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and in kanban rack

Location:

Rev E

08/12/03

sq

34.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/04

Job Completion



MF 08-12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

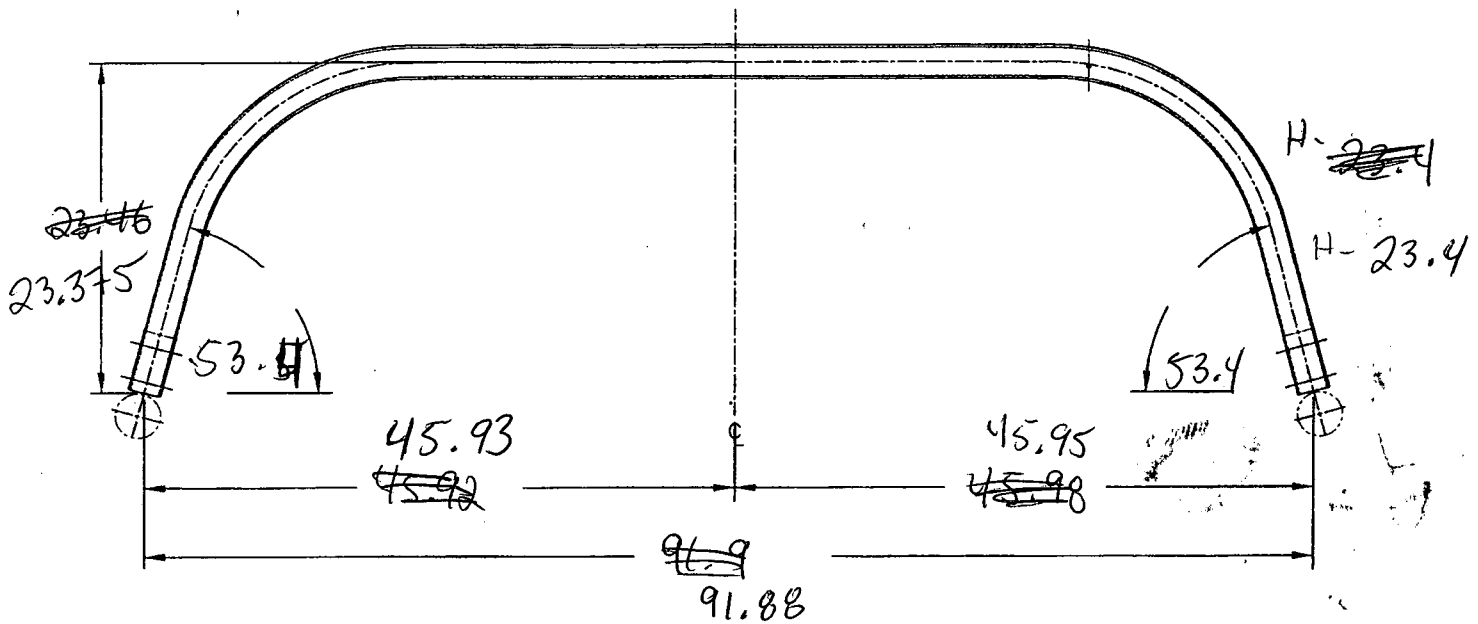
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	41043
Description: Crosstube High Aft (407)		Part Number:	D407-667-205
Inspection Dwg: D407-667-245	Rev: DE	Page 1 of 1	

08.08.10

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	45.86	45.98
Angle	54	56
Total Span	91.72	91.96



Comments
Dims Erased were recorded on the incorrect B# W/O.

QC15 Inspection	
Date	06.11.07

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

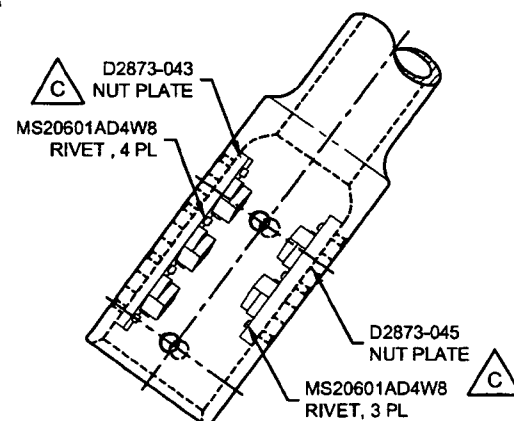
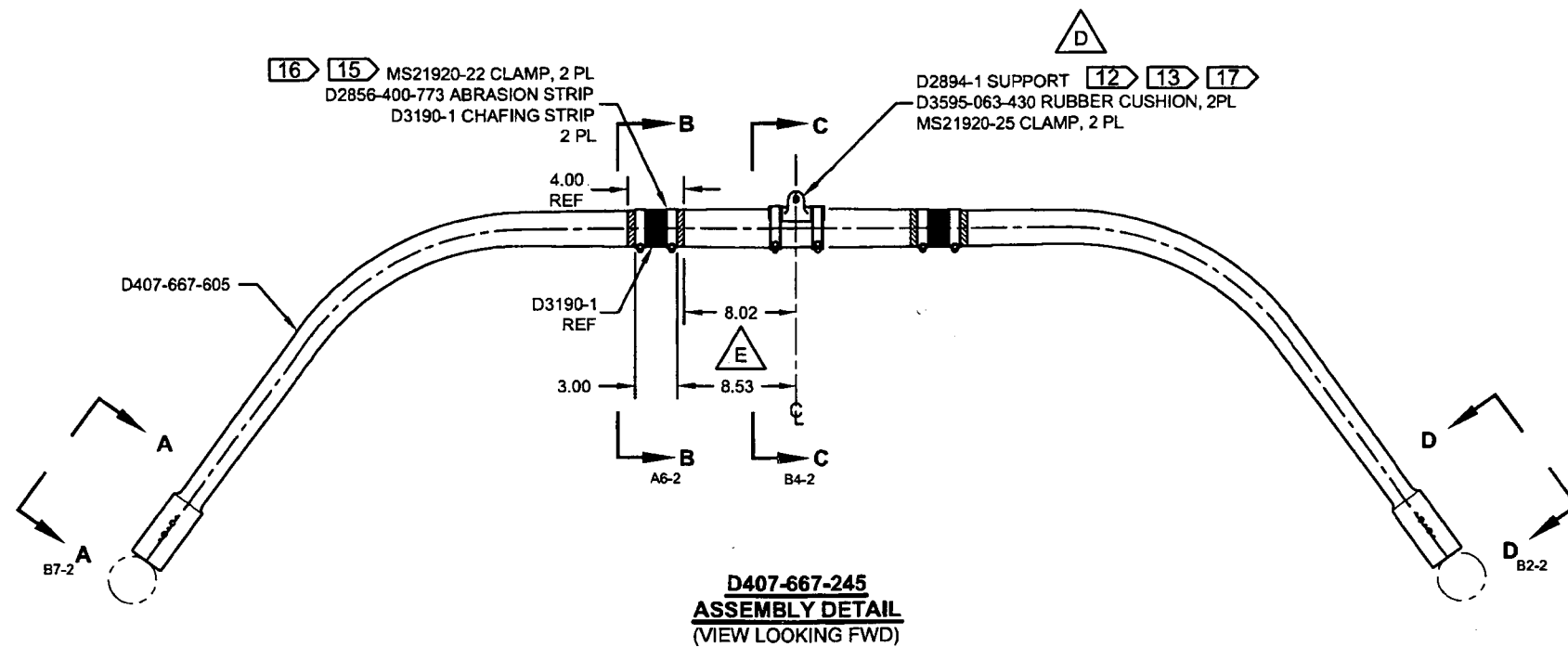
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WITHOUT NOTICE
WORK ORDER
NO. 41043

GENERAL NOTES:

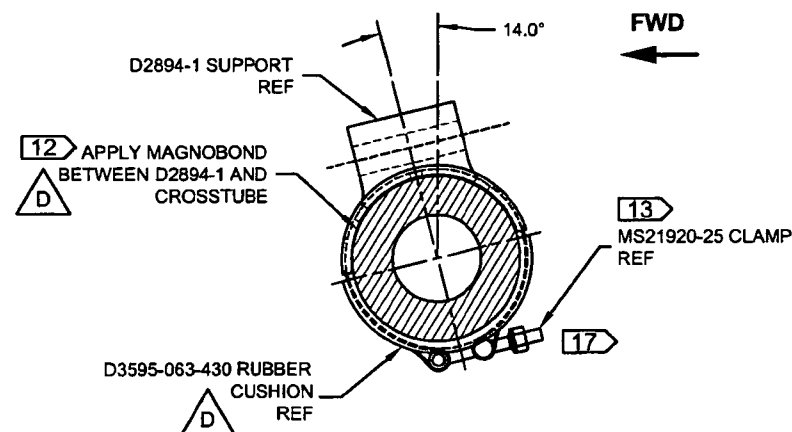
- MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 27.7 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, PER QSI 035.
- INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE OPPOSITE D2894-1 SUPPORT.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/12

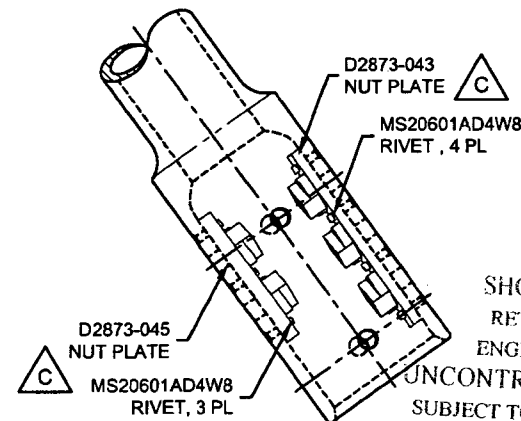
F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D407-667-245	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



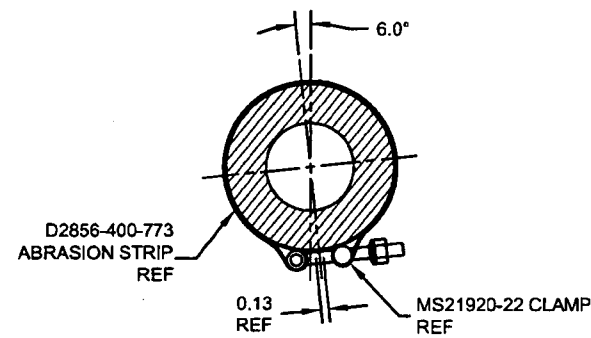
C7-2 **VIEW A-A CUFF DETAIL**
SCALE 4X



C4-2 **SECTION C-C**
SCALE 4X



C2-2 **VIEW D-D CUFF DETAIL**
SCALE 4X

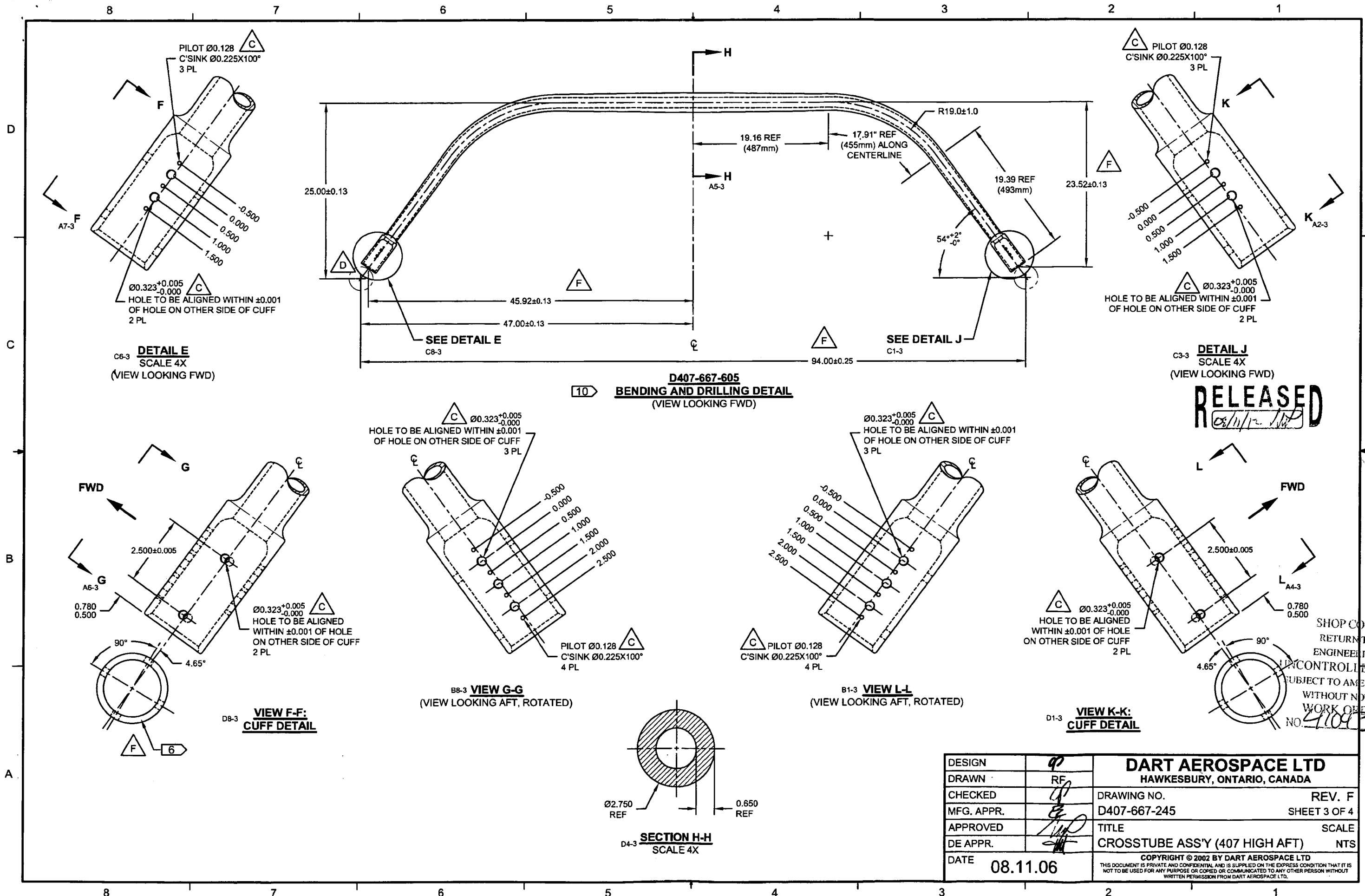


C5-2 **SECTION B-B**
SCALE 4X, 2PL

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NO. 41043

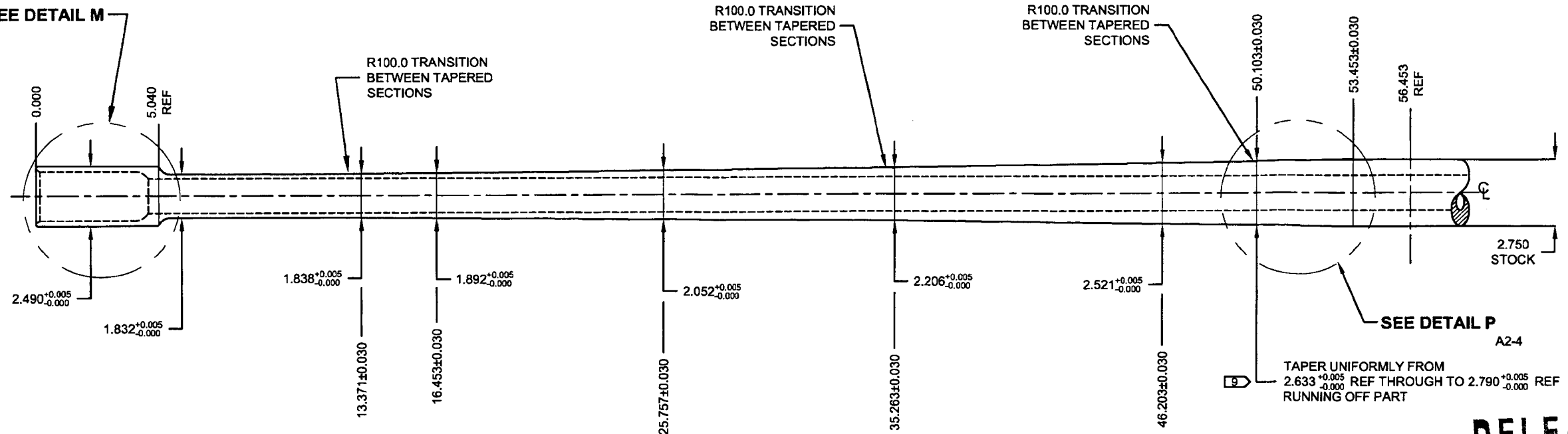
RELEASED
08/11/12

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. F
MFG. APPR.	90	D407-667-245	SHEET 2 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	90	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



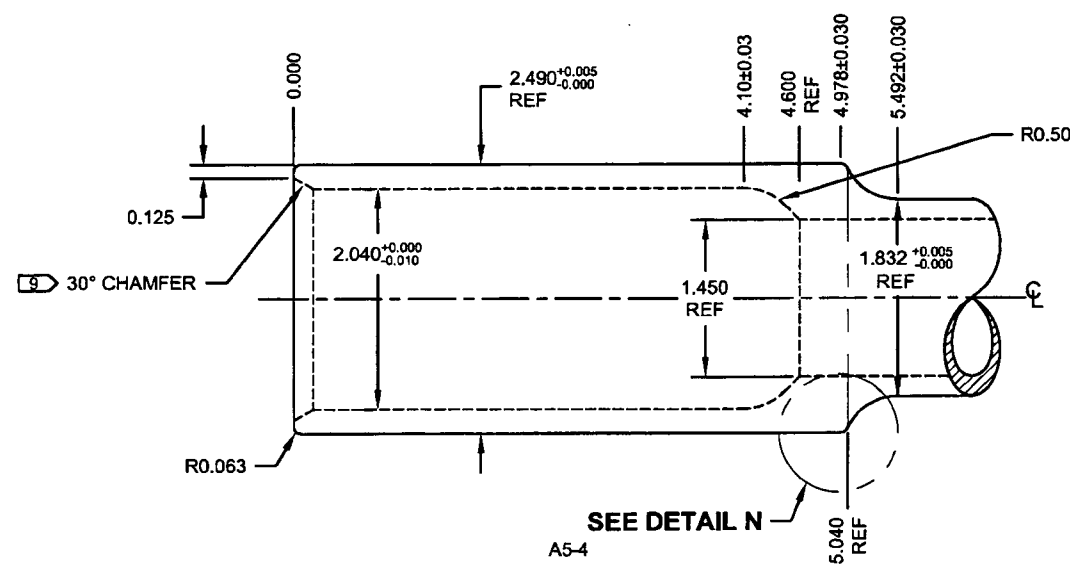
DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D407-667-245	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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SEE DETAIL M
A7-4

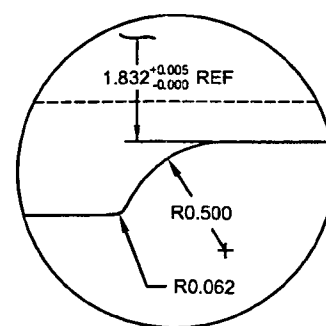


D407-667-245 MACHINING DETAIL

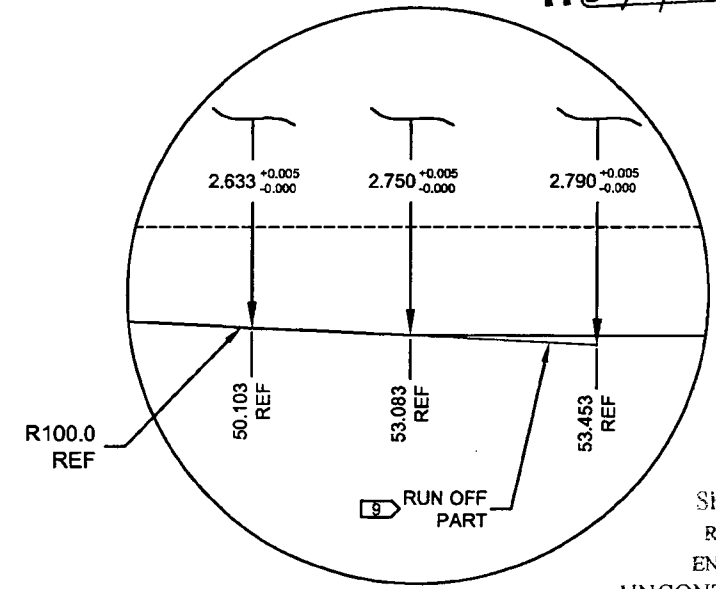
RELEASED
08/11/12



D8-4 DETAIL M: CROSSTUBE CUFF
SCALE 3X



B6-4 DETAIL N: CUFF TRANSITION
SCALE 2X



C1-4 DETAIL P: TAPER RUN-OFF
NOT TO SCALE

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 41043

DESIGN	q	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	q	DRAWING NO.	REV. F
MFG. APPR.	E	D407-667-245	SHEET 4 OF 4
APPROVED	up	TITLE	SCALE
DE APPR.	th	CROSSTUBE ASSY (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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LIQUID PENETRANT TEST REPORT

P- 08827

CLIENT DACT Aerospace DATE Nov. 19-2008 PAGE 1 OF 1
 ATTENTION LINDA LACELLE ACUREN JOB NO. 188-08-1121 TIME AM ☒ PM ☐
 ADDRESS 1270 ABERDEEN ROOM NO.
Waukegan, IL WORK LOCATION SAME ADDRESS, SHOP.
 ACCEPTANCE STD. QST-038 REV/DATE 2005
 PROJECT N/A
 ITEM(S) EXAMINED 407 HIGH AFT X-TUBE ASSEMBLY, 407 FUSED X-TUBE
212 X-TUBE, LOW STANDARD AFT.

JOB DESCRIPTION PROCEDURE NO. LT-001 REV/DATE 12 NOV 07 TECHNIQUE NO. LT-002 REV/DATE NOV. 07 08

PART NO. D212-664-247/D407667205/D407667105 MATERIAL ALUMINUM THICKNESS

SCOPE 100% EXTERNAL WET FLOUORESCENT INSPECTION
ON UNITS

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☐ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
 FAMILY BRAND 2LG7 MINIMUM DWELL TIME 10 MIN. BLACK LIGHT S/N 8171 ☒ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
 PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
 DEVELOPER SK052 MINIMUM DWELL TIME 10 MIN. OTHER CAL FEB 12-08
 DEVELOPER TYPE ☐ NON-AQUEOUS ☐ AQUEOUS ☐ DRY LIGHT METER S/N CAL DUE DATE

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
 SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
JB	units		
41042		/	
42878		/	
43340		/	
41043			
No INDICATIONS			
WERE FOUND ON THESE			
PARTS THAT WERE			
EXAMINED			

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Jason Muntach DTR # E-20057
 TECHNICIAN (SIGNATURE): Mike Johnson REPORT REVIEWED BY:
 NAME (PRINT): Mike Johnson NAME INITIALS
 CGSB LEVEL II SNT LEVEL CGSB LEVEL SNT LEVEL
 CGSB REG. NO. 0666 CGSB REG. NO.